

Date: Tuesday, 30/09/2008 8:54:15 AM  
User: Julie Lecocq

## Process Sheet

|                       |  |  |  |                  |                               |  |  |
|-----------------------|--|--|--|------------------|-------------------------------|--|--|
| Customer              | : CU-DAR001 Dart Helicopters Services                |  |  | Drawing Name     | : HI-STEP LEG ASSEMBLY        |  |  |
| Job Number            | : 42344  |  |  | Part Number      | : D3065041                    |  |  |
| Estimate Number       | : 10385  |  |  | Drawing Number   | : D3065 REV B                 |  |  |
| P.O. Number           | :  |  |  | Project Number   | : N/A                         |  |  |
| This Issue            | : 30/09/2008 S.O. No. :                              |  |  | Drawing Revision | : B                           |  |  |
| Prsht Rev.            | : NC   |  |  | Material         | :                             |  |  |
| First Issue           | : / / Type : SMALL /MED FAB                          |  |  | Due Date         | : 15/10/2008 Qty: 50 Um: Each |  |  |
| Previous Run          | : 41445  |  |  |                  |                               |  |  |
| Written By            | :  |  |  |                  |                               |  |  |
| Checked & Approved By | : <u>JUL 08.9.30</u>                                 |  |  |                  |                               |  |  |
| Comment               | : Est Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RF |  |  |                  |                               |  |  |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description:  |  |
|---------|-----------------------|---|--|
| 1.0     | 42344A                | STEP SPACER   |  |
|         |                       | Comment: Sub-Component STEP SPACER<br>1 x D3065-1 Batch <u>B42344</u>                 |  |
| 2.0     | 42344B                | STEP SPACER   |  |
|         |                       | Comment: Sub-Component STEP SPACER<br>1 x D3065-3 Batch <u>B41445</u>                 |  |
| 3.0     | 42344C                | STEP LEG  |  |
|         |                       | Comment: Sub-Component STEP LEG<br>2 x D3065-5 Batch <u>B41445C (15x)</u>             |  |
| 4.0     | 42344D                | STEP SPACER   |  |
|         |                       | Comment: Sub-Component STEP SPACER<br>1 x D3065-7 Batch <u>B38650 (8x)</u>            |  |
| 5.0     | MS20470AD44           | Rivet, Universal Head   |  |
|         |                       | Comment: Qty.: 30.0000 Each(s)/Unit Total: 1500.0000 Each(s)<br>Rivet, Universal Head |  |
|         |                       | Pick:<br>Qty Part Number Description Batch  |  |
|         |                       | 30 MS20470AD4-4 Rivet <u>M109545</u>  |  |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 30/09/2008 8:54:15 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 42344

Part Number: D3065041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3065 and Identify as D3065-041

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

3AD 08-12-03 50

9.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/03 AF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion:



MF 08-12-03

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

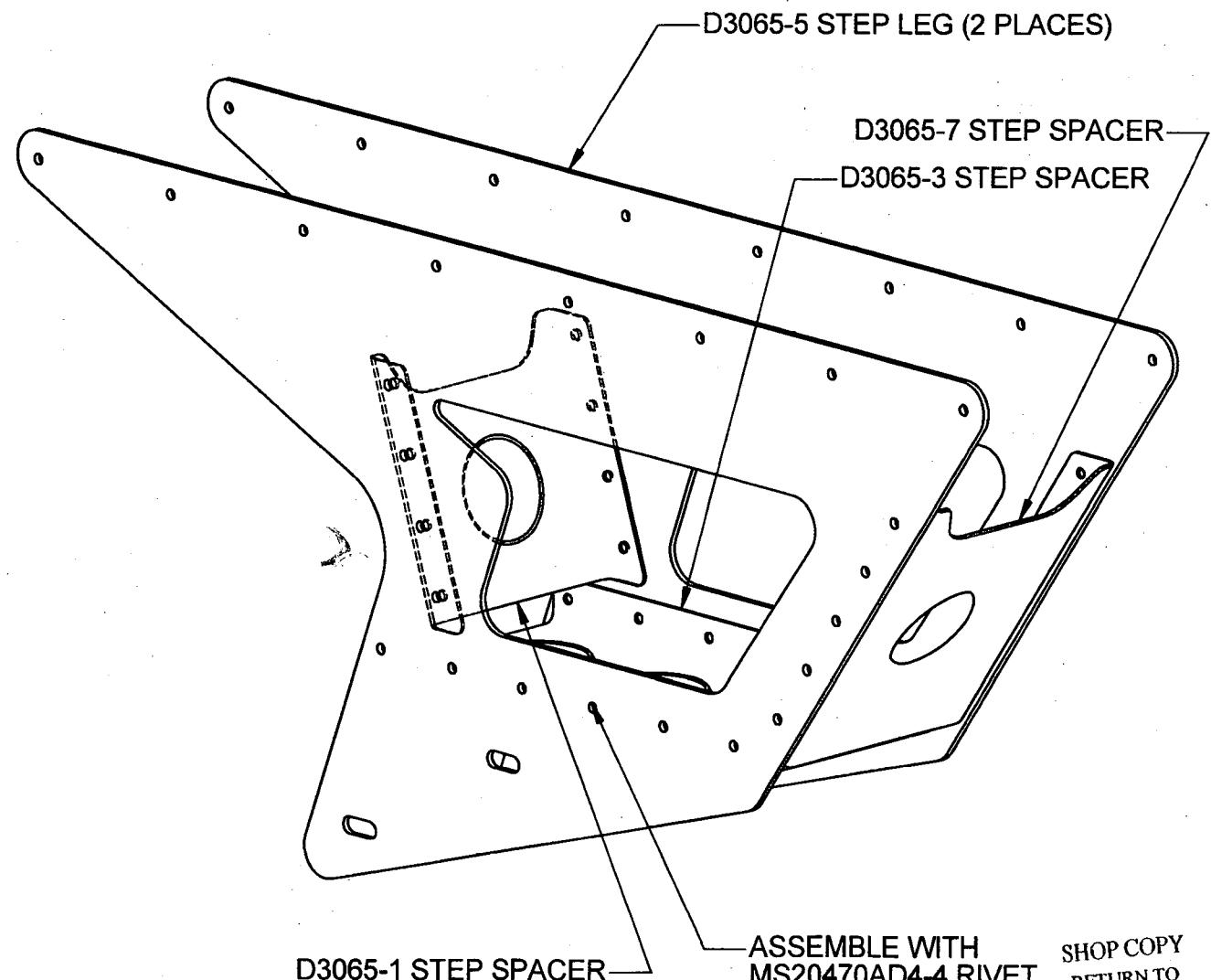
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**DART**

|                         |                       |  |                        |
|-------------------------|-----------------------|--|------------------------|
| DESIGN<br><i>CP</i>     | DRAWN BY<br><i>CB</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>PH</i>    | APPROVED<br><i>MM</i> | DRAWING NO.<br><b>D3065</b>                              | REV. B<br>SHEET 1 OF 5 |
| DATE<br><b>06.05.23</b> |                       | TITLE<br><b>STEP LEG ASSEMBLY</b>                        | SCALE<br>1:2           |
| A                       | 02.09.11              | NEW ISSUE  |                        |
| B                       | 06.05.23              | ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5               |                        |

**RELEASED***06.05.20***D3065-041 STEP LEG ASSEMBLY**

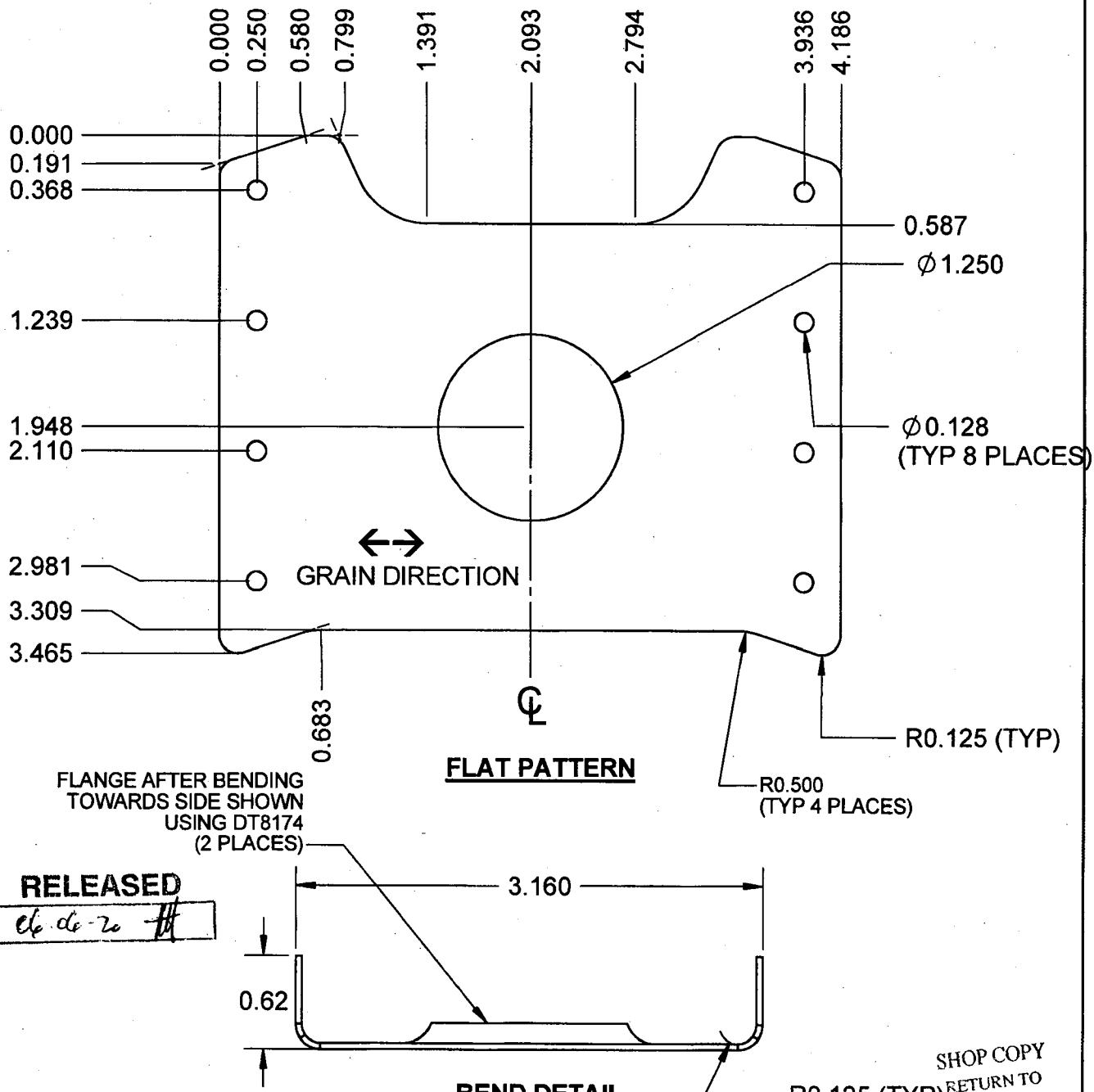
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WORK ORDER  
NO. *42344*

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| DATE<br>06.05.23     | TITLE<br><b>STEP LEG ASSEMBLY</b> | SCALE<br>1:1   |                        |

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

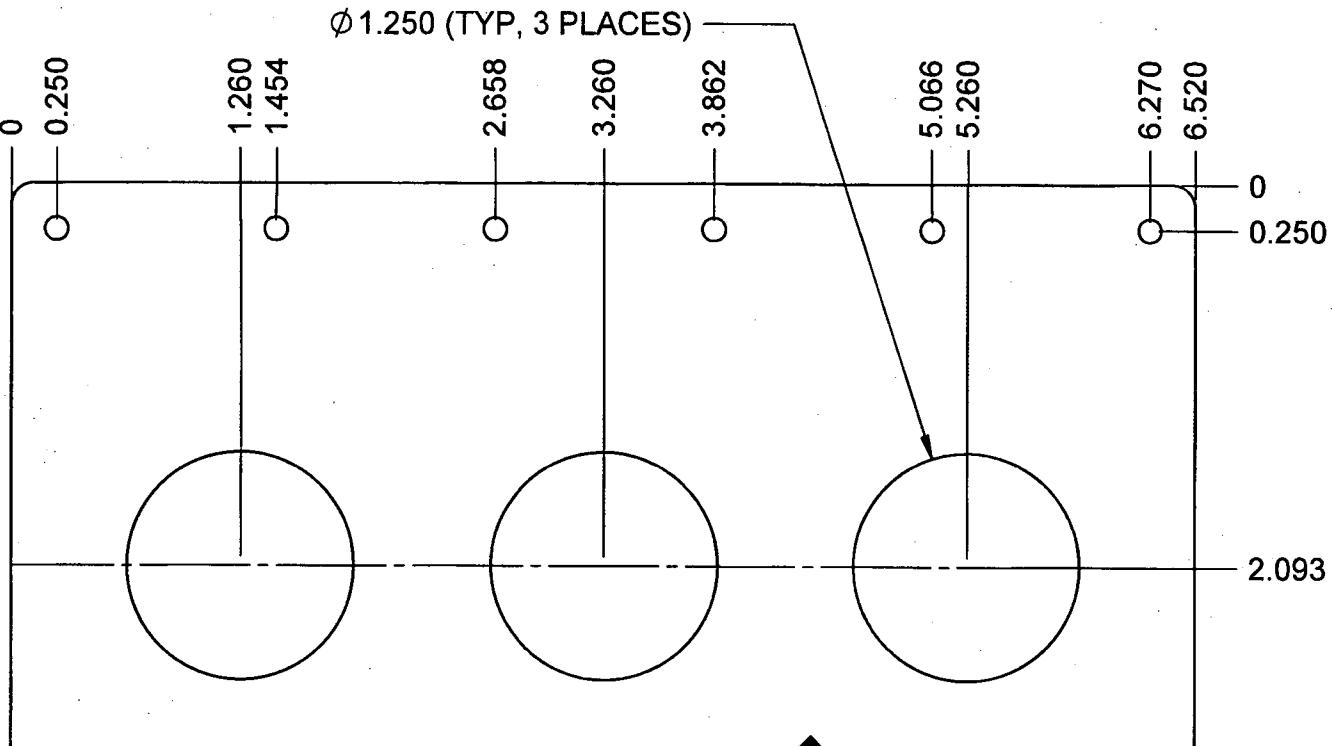
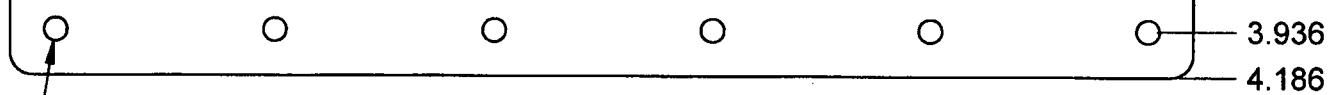
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| CHECKED<br><i>PH</i> | APPROVED<br><i>MH</i>      | DRAWING NO.<br>D3065                              | REV. B | SHEET 3 OF 5 |
| DATE<br>06.05.23     | TITLE<br>STEP LEG ASSEMBLY | SCALE<br>1:1                                      |        |              |

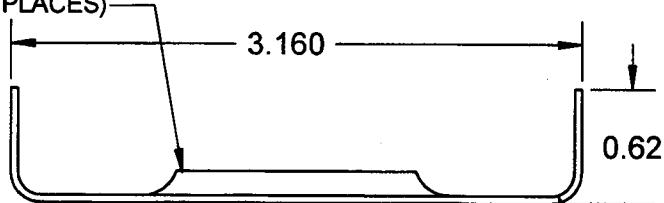
**FLAT PATTERN**  
GRAIN DIRECTION

FLANGE AFTER TOWARDS SIDE  
SHOWN USING DT8174 (3 PLACES)

$\varnothing 0.129$  (TYP, 12 PLACES)

**RELEASED**

*06 Oct 20* *MH*

**BEND DETAIL**

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WORK ORDER  
*No. 1234*

**D3065-3 STEP SPACER**

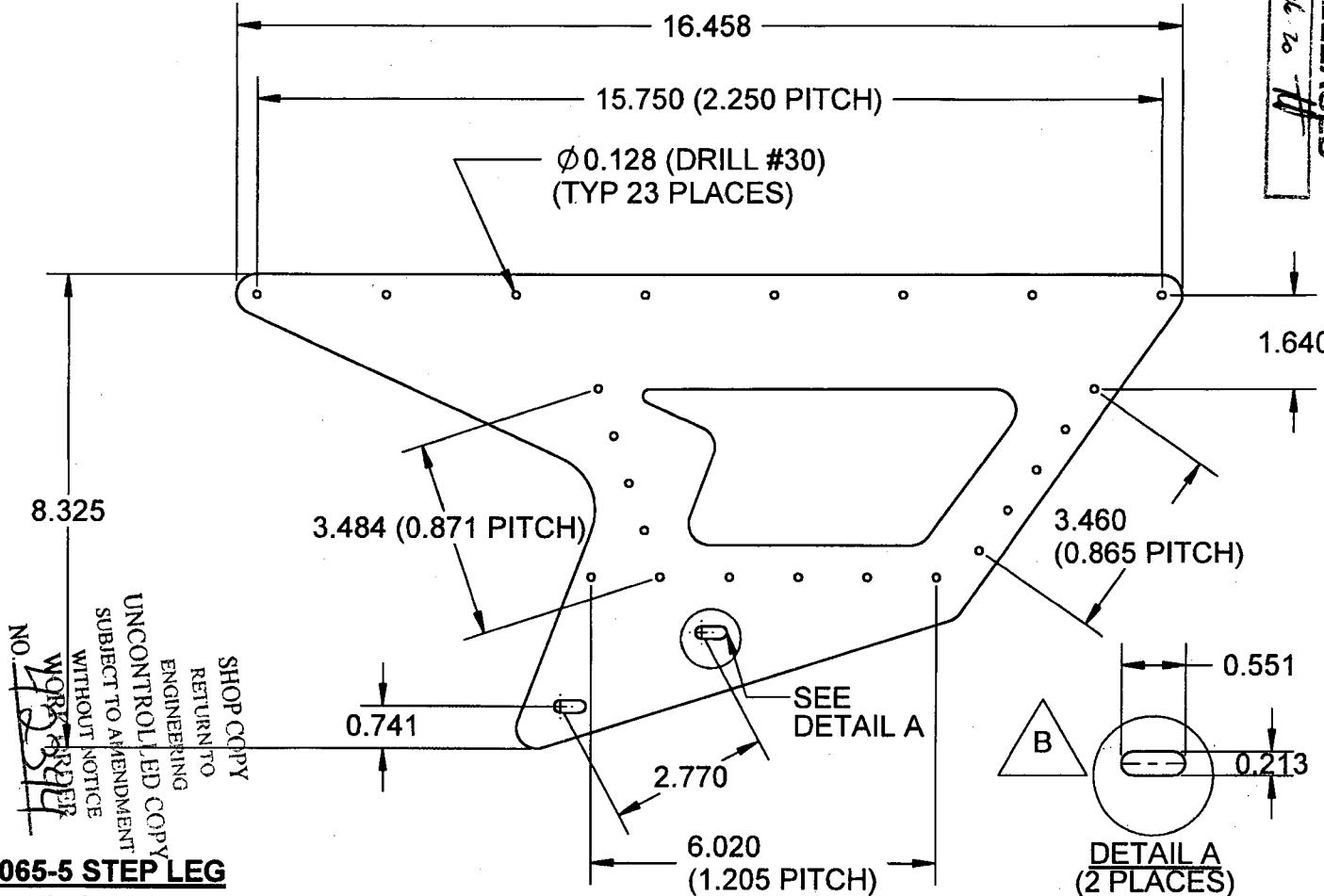
- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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**DART**

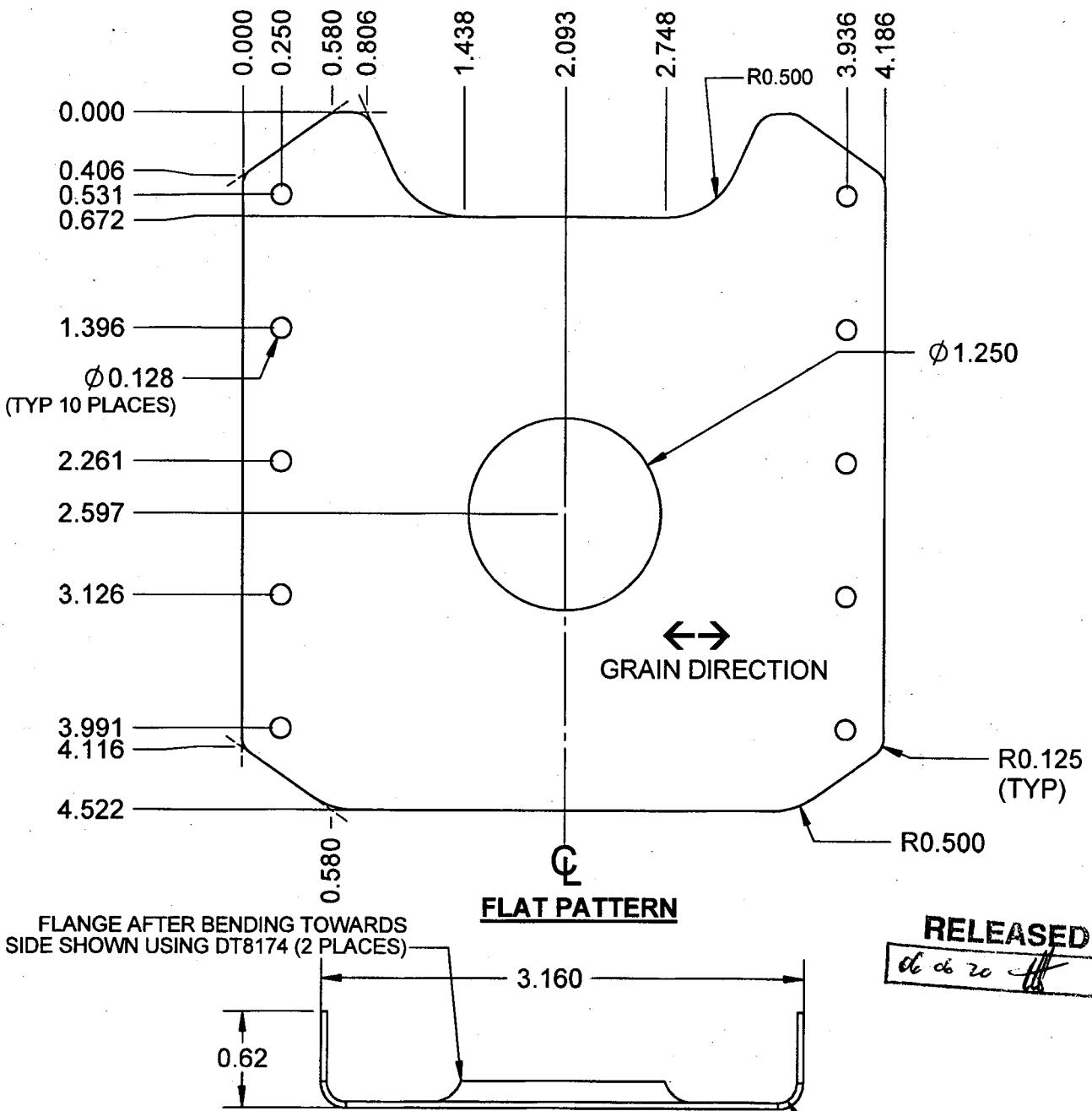
|                        |                            |  |
|------------------------|----------------------------|--|
| DESIGN<br><i>CP</i>    | DRAWN BY<br><i>C.B.</i>    | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED<br><i>P.H.</i> | APPROVED<br><i>J.H.</i>    | DRAWING NO.<br>D3065                                     |
| DATE<br>06.05.23       | TITLE<br>STEP LEG ASSEMBLY | REV. B<br>SHEET 4 OF 5<br>SCALE<br>1:3                   |

**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES



|                         |                                   |   |        |              |
|-------------------------|-----------------------------------|---|--------|--------------|
| DESIGN<br><i>GP</i>     | DRAWN BY<br><i>CB</i>             | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |        |              |
| CHECKED<br><i>PH</i>    | APPROVED<br><i>MM</i>             | DRAWING NO.<br><b>D3065</b>                       | REV. B | SHEET 5 OF 5 |
| DATE<br><b>06.05.23</b> | TITLE<br><b>STEP LEG ASSEMBLY</b> |   | SCALE  | <i>1:1</i>   |



## **D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC.)
  - 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
  - 3) PART IS SYMMETRIC ABOUT CENTERLINE
  - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
  - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 6) ALL DIMENSIONS ARE IN INCHES

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RETURN TO  
2024T3S.040) ENGINEERING  
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WITHOUT NOTICE  
WORK ORDER  
NO. 110-344